

Amendments to the Claims

Cancel Claims 1, 14, and 27-50.

Enter new claims, Claims 51 - 72.

The following listing of claims replaces all prior versions and listings of claims in this application. These new claims are filed because the last listing was misnumbered with respect to two claims and because as a result of the phone interview of Jun07.2010 the applicant has agreed to cancel Claims 1 and 14. The amendments to Claim 27-50 are to the claim numbers only and do not require a new search. The new claims comply with 35 CFR § 1.171 and do not enlarge the scope of the original claims or add new matter.

The total of number claims has been reduced from 26 to 22. The number of independent claims is two. No new fees are necessitated by these claim amendments.

Listing of the Claims

Claims 1-50 (canceled)

Claim 51 (new)

A method for manufacturing a circular metal tank wall from an elongate metal sheet, wherein said metal sheet has an upper edge, said method comprising the steps of:

- (a) providing the elongated metal sheet;
- (b) bending an upper edge of the metal sheet to produce an upper bend along the upper edge;
- (c) bending a lower edge of the metal sheet produce a lower bend along the lower edge;
- (d) aligning the lower bend into proximity with the upper bend;
- (e) welding the upper edge of the metal sheet to the lower edge of the metal sheet to form the circular tank wall, wherein the upper bend and the lower bend of the metal sheet cooperate to form a roller track, and wherein the roller track has two opposing roller track sides spaced apart to accommodate rollers that can engage the roller track and support the tank wall as it is being constructed; and,
- (f) rotating the tank wall about its longitudinal axis on the rollers such that the tank wall moves upwards as Step (d) and Step (e) are performed.

Claim 52 (new)

The method of Claim 51, wherein the elongated metal sheet provided at Step (a) is coiled, and wherein Step (a) comprises the step of decoiling the metal sheet.

Claim 53 (new)

The method of Claim 51, wherein the metal sheet is corrugated prior to Step (e).

Claim 54 (new)

The method of Claim 51, wherein Step (d) comprises the steps of:

- (d1) gross positioning the upper and lower bends; and,
- (d2) fine positioning the upper and lower bends.

Claim 55 (new)

The method of Claim 51, wherein at least one of the rollers is motorized and wherein Step (f) is performed by using the motorized rollers.

Claim 56 (new)

The method of Claim 51, wherein the metal is one of aluminum, galvanized steel, stainless steel, and carbon steel.

Claim 57 (new)

The method of Claim 51, wherein a first one of the roller track sides is the tank wall and wherein a second one of the roller track sides is formed from an opposing vertical portion of the lower bend.

Claim 58 (new)

The method of Claim 51, further comprising the step of cutting an upper edge of the tank wall to create an upper circumferential tank edge that is substantially parallel to the ground.

Claim 59 (new)

The method of Claim 51, further comprising the step of cutting a lower edge the tank wall to create a lower circumferential tank edge that is substantially parallel to the ground.

Claim 60 (new)

A circular metal tank wall manufactured according to the method of Claim 51.

Claim 61 (new)

A tank comprising the circular metal tank wall of Claim 60.

Claim 62 (new)

A system for manufacturing a circular metal tank wall from an elongate metal sheet, said system comprising:

- a. at least one bender/corrugator, wherein said bender/corrugator bends an upper edge of the metal sheet one or more times to produce an upper bend and wherein said bender/corrugator bends a lower edge of the metal sheet one or more times to produce a lower bend;
- b. a welder used to weld the upper edge of the metal sheet and the lower edge of the metal sheet together, wherein the upper bend and the lower bend cooperate to form a roller track when the upper edge of the metal sheet and the lower edge of the metal sheet are welded, wherein the roller track has two opposing track sides; and,

- c. a plurality of rollers that are received between the roller track sides, wherein the tank wall is supported by said rollers when they are received between the roller track sides, and wherein the tank wall rides on said rollers when the tank wall is rotated about its longitudinal axis.

Claim 63 (new)

The system of Claim 62 wherein one bend produced by said bender is a chair-bend.

Claim 64 (new)

The system of Claim 62 wherein one bend produced by said bender is an "L"-bend.

Claim 65 (new)

The system of Claim 62, further comprising a decoiler used to decoil a coil of the elongate metal sheet prior to bending the upper and lower edges of the metal sheet.

Claim 66 (new)

The system of Claim 62, wherein the upper bend produced by said bender has an angle of between 45 and 135 degrees with the metal sheet.

Claim 67 (new)

The system of Claim 62, wherein the bends produced by said bender cooperate to produce a spacing of 5 mm to 100 mm between the roller track sides.

Claim 68 (new)

The system of Claim 62, further comprising a corrugator used to corrugate the metal sheet.

Claim 69 (new)

The system of Claim 62, wherein at least one of said rollers is motorized, and wherein said motorized roller causes rotation of the tank about a longitudinal axis of the tank as the tank is constructed.

Claim 70 (new)

The system of Claim 62, further comprising a positioner, wherein said positioner is used to align the upper bend proximate the lower bend for welding the upper and lower edges of the metal sheet together.

Claim 71 (new)

The system of Claim 70, further comprising a welding pre-aligner, wherein said pre-aligner is used to gross position the upper and lower bends before the upper and lower bends are aligned by said positioner.

Claim 72 (new)

The system of Claim 62, further comprising a vertical coil seam welder, wherein said vertical coil seam welder is used to butt-weld an end of a first metal sheet to an end of a second metal sheet.